

Work Order ID 120961

646.9710

120961

Page 1

June-16-14 1:14:35 PM

B120961

Item ID: 646.9710

REV-C

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Body

Start Date: 6/16/14

Start Qty: 22.00

22

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date: 14-06-17

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.9700

C

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 7.425"

0.00

B. = 14/07/26

22

φ

DAS
08
9-89

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB130

DWG REV: C

FOLIO REV: A A

0.00

B. = 14/07/30
B. = 14/07/31

22

φ

DAS
08
9-89

2- deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 120961

June-16-14 1:14:35 PM

120961

Page 3

Item ID: 646.9710 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Body
Start Date: 6/16/14 Start Qty: 22.00 ***22*** Cust Item ID:
Required Date: 6/16/14 Req'd Qty: 22.00 ***22*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
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140

Outsource4

Outsource process - Anodize

Memo PO25329 0.00

Issue P/O to ATG :

1- Black Anodize as per Dwg 646.9700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

12 14-08-07

150	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Packaging

Packaging

Memo 0.00

22 14-08-22

155	QC5- Inspect part completeness to step on W/O	0.00							
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155

QC

Quality Control

Memo 0.00

22 14-08-22 DAS 9 9-88

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DART AEROSPACE LTD		Work Order:	120961
Description: Body		Part Number:	646.9710
Inspection Dwg: 646.9700 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13 x 45°	+/-0.010 x 0.5°	.125X45°	—		Vern	42-06
1.500	+/-0.005	1.500	—		"	
0.352	+0.005/-0.000	.354	—		"	
0.10 x 45°	+/-0.010 x 0.5°	.100X45°	—		"	
0.875	+/-0.005	.879	—		"	
0.700	+/-0.005	.700	—		"	
5.500	+/-0.005	5.500	—		"	
0.660	+/-0.005	.660	—		"	
0.660	+/-0.005	.660	—		"	
0.278	+/-0.002	.278	—		"	
0.339	+/-0.002	.339	—		"	
0.352	+/-0.002	.352	—		"	
0.372	+/-0.002	.372	—		"	
1.067	+/-0.002	1.067	—		"	
2.608	+/-0.002	2.608	—		"	
2.750	+/-0.002	2.750	—		"	
2.892	+/-0.002	2.892	—		"	
3.348	+/-0.002	3.348	—		"	
3.597	+/-0.002	3.597	—		"	
3.847	+/-0.002	3.847	—		"	
0.351	+/-0.002	.0351	—		"	
0.544	+/-0.002	.544	—		"	
2.195	+/-0.002	2.195	—		"	
2.304	+/-0.002	2.304	—		"	
2.451	+/-0.002	2.451	—		"	
2.639	+/-0.002	2.639	—		"	
3.395	+/-0.002	3.395	—		"	
3.495	+/-0.002	3.495	—		"	
4.551	+/-0.002	4.551	—		"	
4.595	+/-0.002	4.595	—		"	
4.687	+/-0.002	4.687	—		"	
4.734	+/-0.002	4.734	—		"	
6.651	+/-0.002	6.651	—		"	

DART AEROSPACE LTD	Work Order:	120961
Description: Body	Part Number:	646.9710
Inspection Dwg: 646.9700 Rev: C		Page 2 of 2

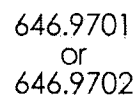
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	Ø.201	—		Vern	M-06
Ø0.177	+0.005/-0.001	Ø.177	—		"	
7.026	+/-0.005	7.026	—		"	
4.245	+/-0.005	4.245	—		"	









Measured by:	ML/DA	Audited by:	DAS 20 9-89	Preliminary Approval:	
Date:	14/07/20	Date:	14-08-01	Date:	

Rev	Date	Change	Revised by	Approved
A	13.06.03	New Issue	KJ	
B	13.07.18	Dwg Rev updated	KJ	
C	14.01.21	Dwg Rev updated	KJ	

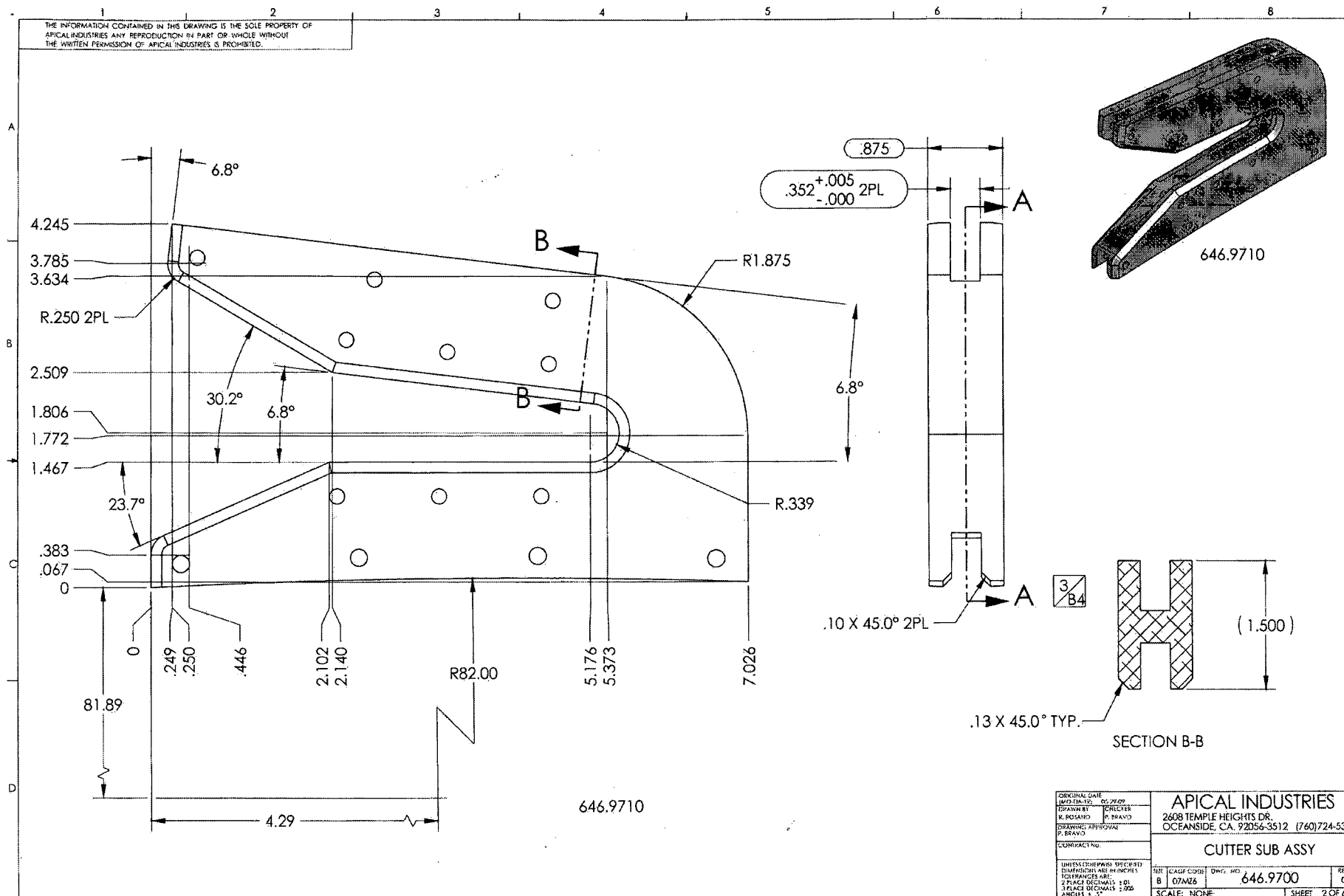
		REVISIONS	
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROLOGUE REVISION: P09		N/C
N/C	INITIAL RELEASE	05/29/09	P. BEAVO
A	INCORPORATED ECH 02744, 03038, 60772	06/04/13	P. BEAVO
B	INCORPORATED ECH 03466	07/20/13	P. BEAVO
C	INCORPORATED ECH 04339	08/09/13	P. BEAVO



- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- ⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

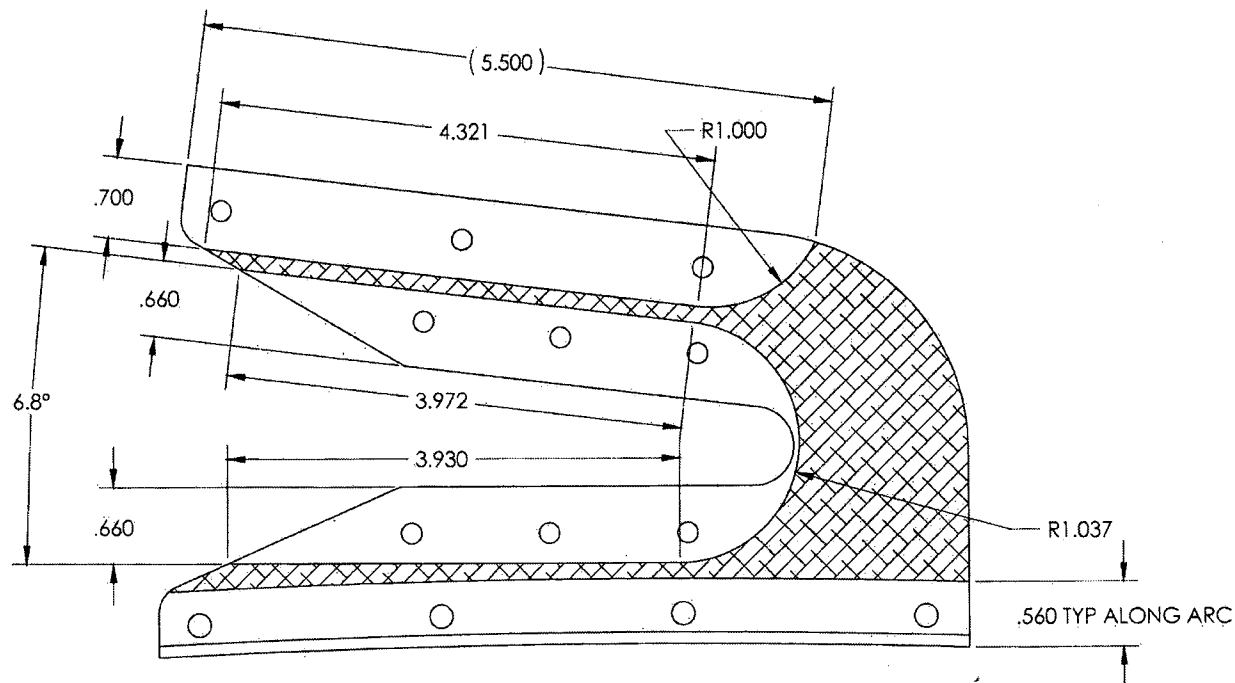
1	6	7	646.9712	BODY (U CHANNEL)		
	6	6	601.1541	LOCKNUT	A521042G08	
A/R	A/R	5	601.2764	RTV. LOCITE 598		
12	12	4	601.2764	WASHER	NAS1147E10832P	
6	6	3	601.2765	SCREW	NAS1232P-0819	
2	2	2	646.9711	BLADE		
	1	1	646.9710	BODY		
			646.9702	CUTTER SUB ASSY (U CHANNEL)		
			646.9701	CUTTER SUB ASSY		
*702	*701	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST		
NEXT ASSY (S)				APICAL INDUSTRIES		
646.9600				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 774-5312		
				CUTTER SUB ASSY		
OPIULMNA DAK NACO DAPI 05-79-01 DRAWN BY: C. BENTLEY P. JOHNSON (P. JOHNSON) DRAWING APPROVAL P. JOHNSON 05-79-02 CONTRACT NO.				DIM (IN) OVERHUNG SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16 PLACE DECIMALS ± .001 1/32 PLACE DECIMALS ± .0005 1/64 PLACE DECIMALS ± .0003		
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ORIGINAL DATE (DD-MN-YY)		APICAL INDUSTRIES	
DESIGNED BY N. ROSARIO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		CUTTER SUB ASSY	
CUTTING TOOL NO.		REV. C	
UNITS (DIMENSIONS SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		DATE: 07/28/86	QTY: 646.9700
SCALE: NONE		SHEET 2 OF 6	

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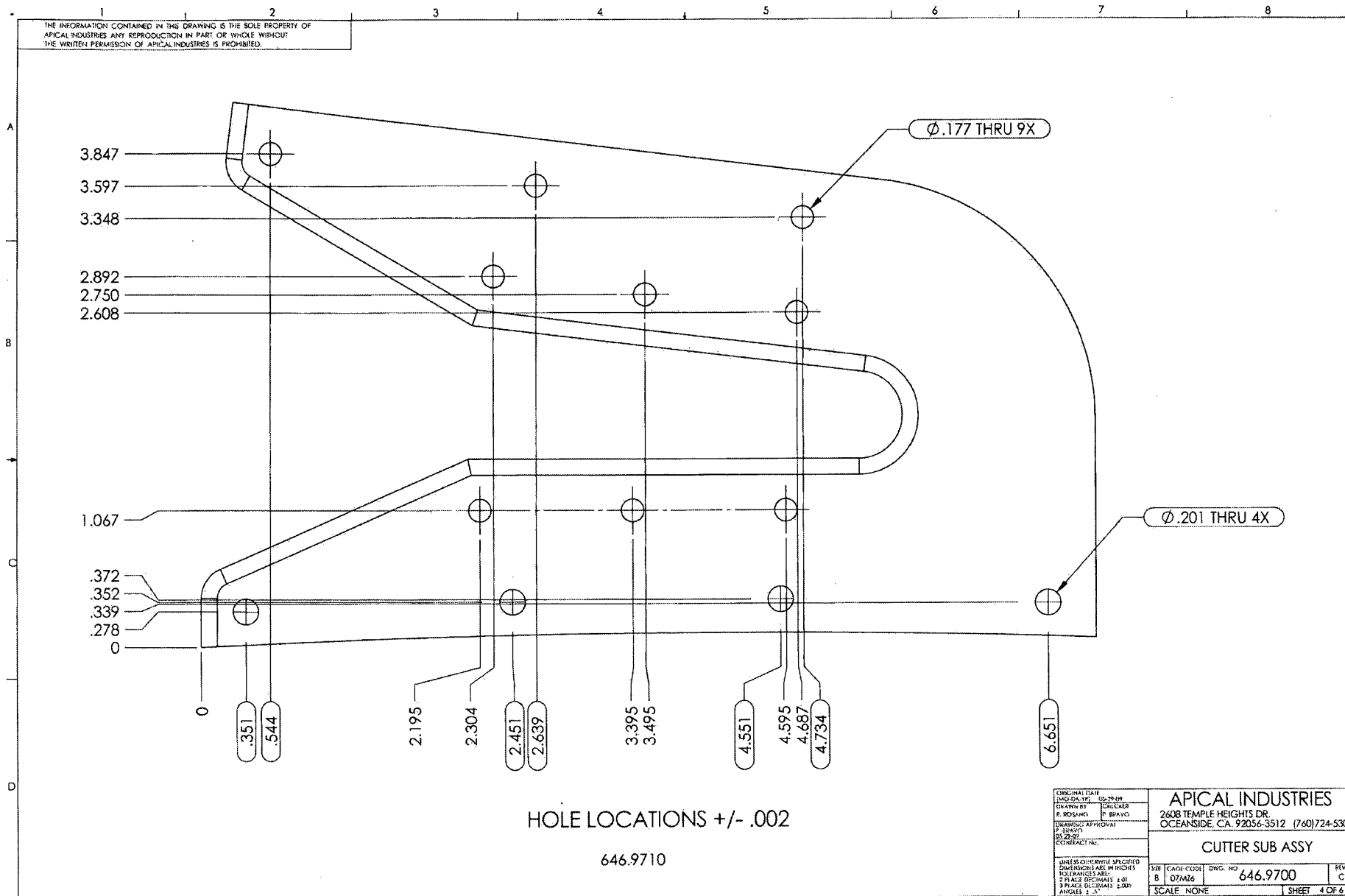


SECTION A-A 2
C6

646.9710

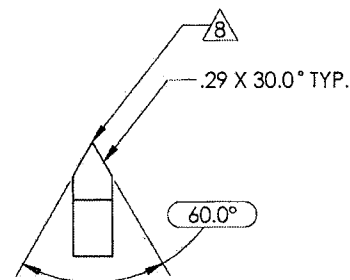
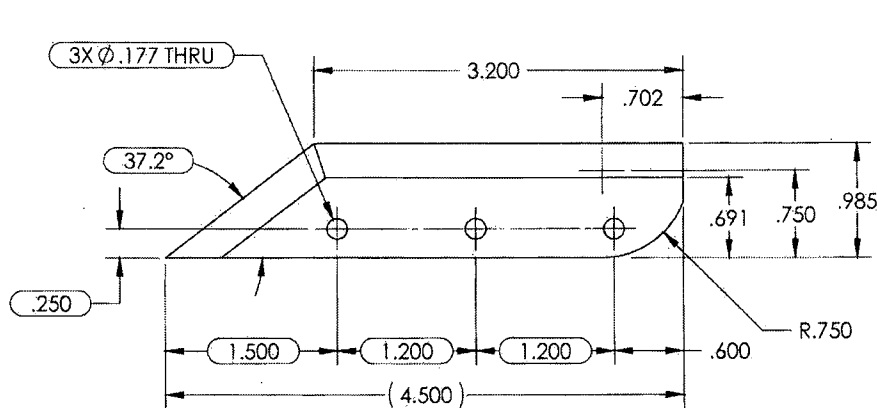
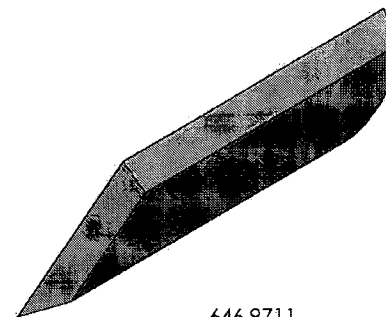
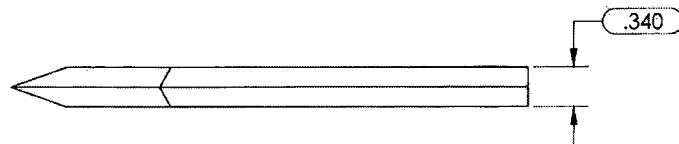
ORIGINAL DATE 10/1/2000 DRAWN BY P. ROYAL P. BRAVO CHECKED BY P. BRAVO DATE 10/2/2000		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
INITIALS OF PERSONS SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B 07M26	DWG NO. 646.9700
SCALE NONE		SHEET 3 OF 6	

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ORIGINAL DATE 1/24/84 BY: JG-28 DR		APICAL INDUSTRIES	
DRAWN BY: R. ROSANO	CHECKED BY: P. BRAYCO	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: P. BRAYCO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DATE: 05/22/84		CUTTER SUB ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .005 ANGLES .5°		SUB: 07M26	DWG. NO. 646.9700
		SCALE: NONE	REV. C
		SHEET 4 OF 6	

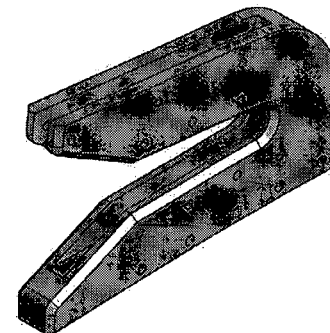
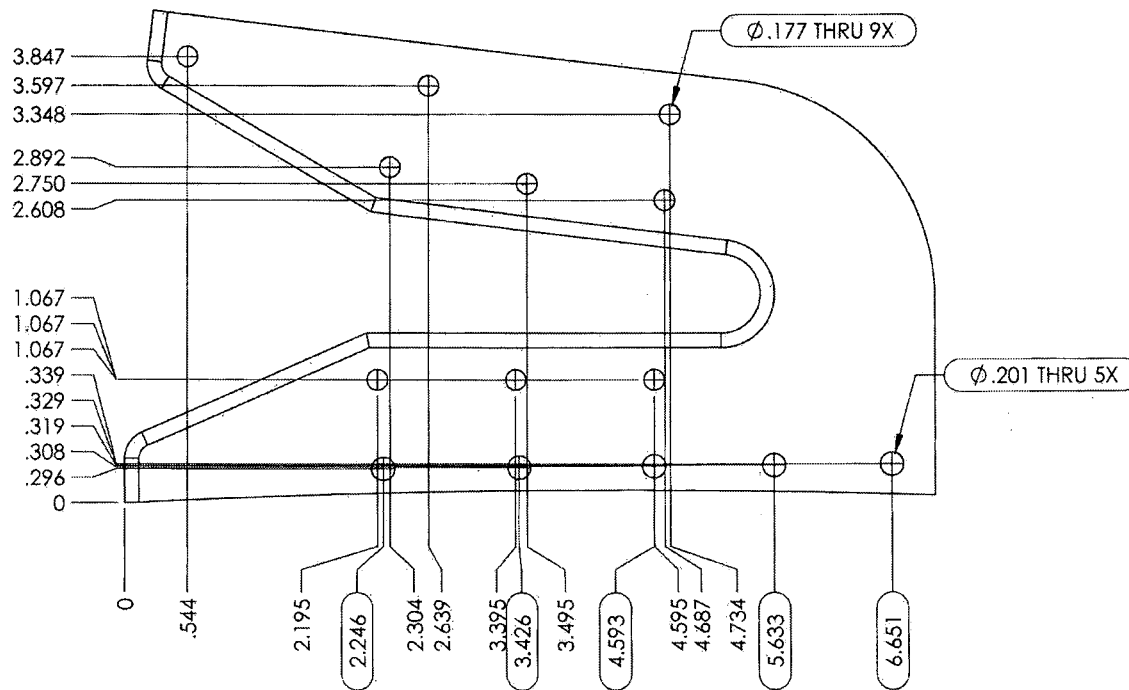
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646.9711

ORIGINAL DATE 1/20/01 09:20:00		APICAL INDUSTRIES	
DRAWN BY P. EDWARDS	CHECKED BY P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO	DATE 02/28/02	CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .003 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET 8	REV. C
SCALE NONE		DWG. NO. 646.9700	SHEET 5 OF 6

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646.9712 $\triangle 9$

646.9712

ORIGINAL DATE: 05-29-09 REV: 02-181		APICAL INDUSTRIES	
DRAWN BY: P. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAVO		CUTTER SUB ASSY	
CONTRACT NO.		REV: 07/02/06	REV: C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS: .010 FRACTIONS: 1/32"		SCALE: NONE	SHEET: 6 OF 6



Engineering Change Request (ECR)

ECR# (Assigned by Engineering Dept.): D-14-05

Employee or Customer Name: JL MENARD

Department or Company Name: DAS Production

Department or Company Phone/Fax/Email: jmenard@dartaero.com

Date: June 06 2014

Subject Drawing/Document: 646.9700

Problem:

Various Issues, see e-mail for details.

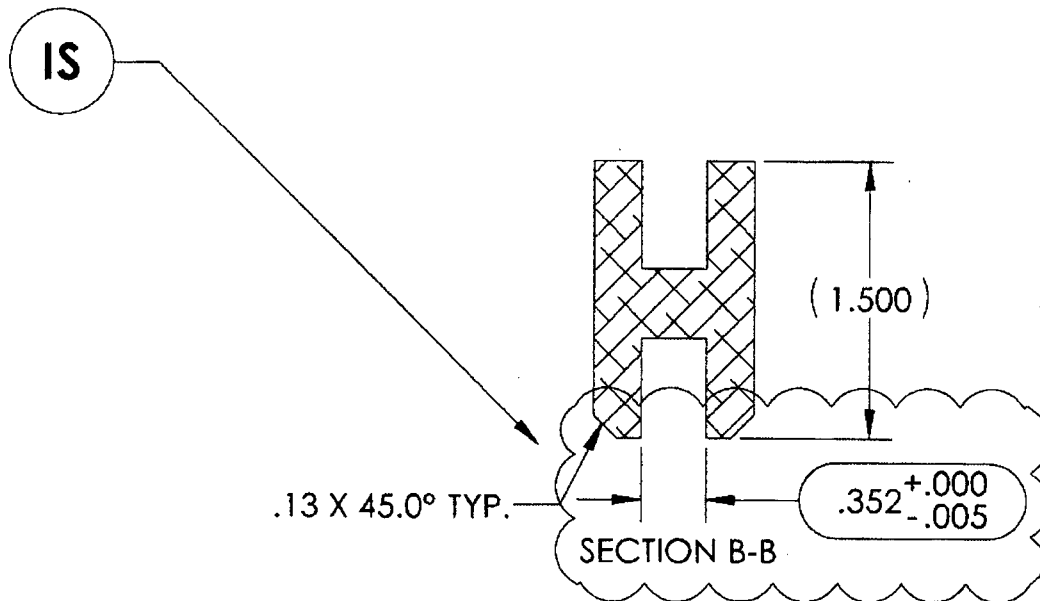
Additional Comments/Clarification:

Engineering Liaison Representative (If applicable):

ECR Approval (Director of Engineering, Director of Operations, Manufacturing Manager or QC Manager):

ECN # (if applicable): 04559

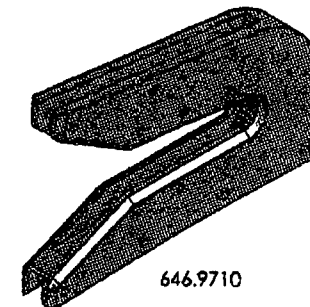
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04559			SHEET 1 OF 1	
	DWG NO. 646.9700	REV: C	PREPARED BY D. MEJIA	DATE: 06/11/2014	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: CUTTER SUB ASSY				
	APPROVED BY: ENGR. <i>[Signature]</i>	MFG	QC	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED DIMENSION AND TOLERANCE				ECR: D-14-05



SHEET 2, ZONE D7 IS:

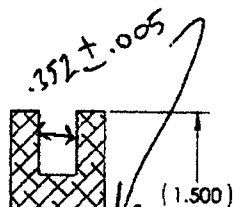
DOCUMENTS EFFECTED:	<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input type="checkbox"/> BOM	CHANGE CATEGORY	DER REVIEW REQUIRED
		<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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646.9710

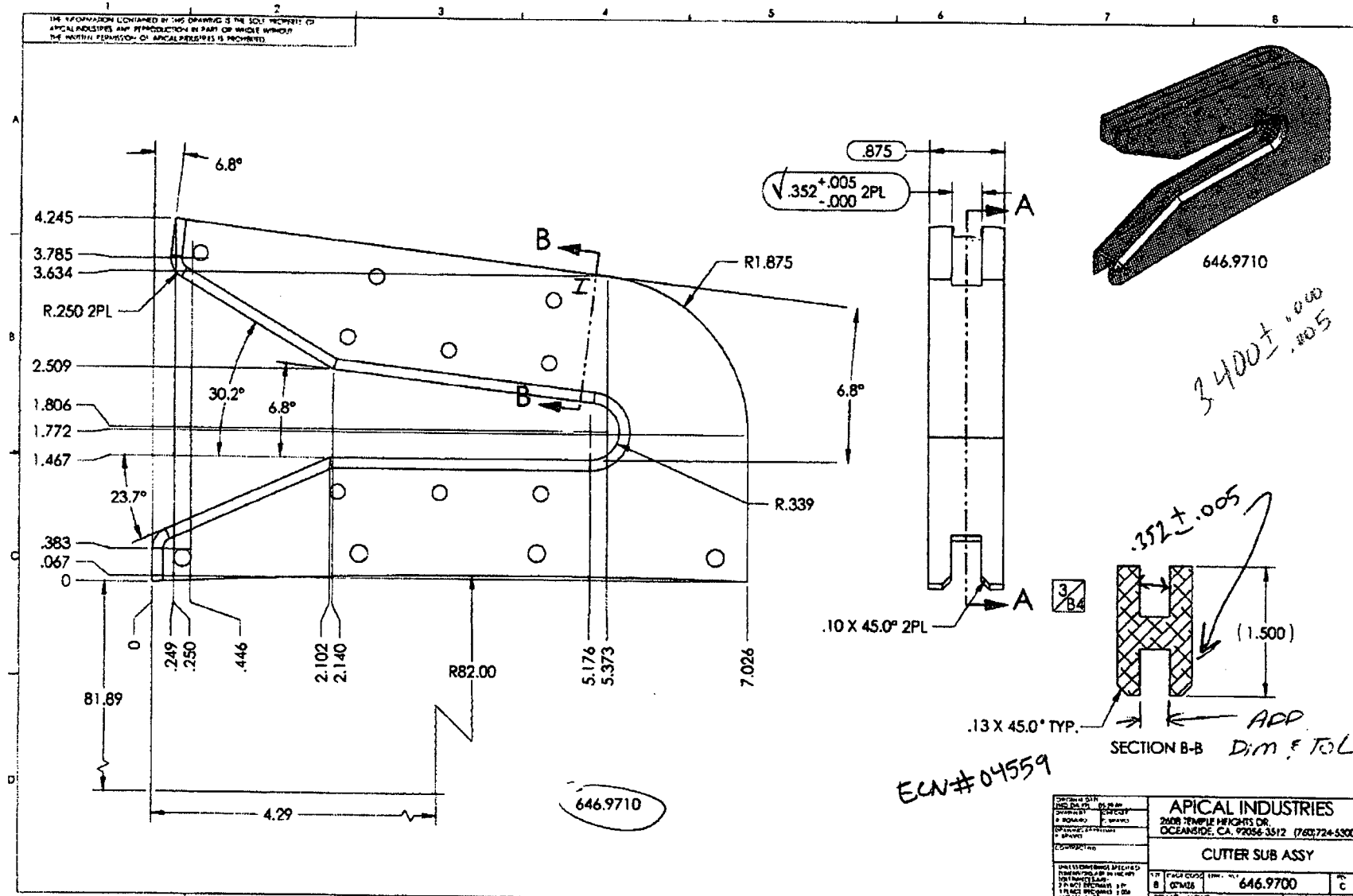
3400 ± .005



SECTION B-B Dim. F.T.O.L.

ECN#04559

DATE: 10/10/80 DESIGNED BY: J. J. JAMES DRAWN BY: J. J. JAMES CHECKED BY: J. J. JAMES APPROVED BY: J. J. JAMES		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
PART NUMBER: 646.9710 QUANTITY: 100 UNIT: EACH		CUTTER SUB ASSY 646.9700	
SCALE: NONE		SHEET: 2 OF 2	



646.9710



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO25329

Purchase Order Date 8/7/2014

PO Print Date 8/7/2014

Page Number 1 of 3

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Buyer

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms Net 30

Ship To Phone

Currency CAD

Ship Via

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req. Qty/ Unit of Measure	PO Unit Price	Extended Price
1	120961	646.9710 ✓	8/15/2014 No 8/15/2014		22.00 8/15/2014 CQ 14/08/20	\$0.00	\$0.
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N							
Line Total:							\$0.
2	120746	647.4114	8/15/2014 No 8/15/2014		32.00 CQ 14/08/20	\$0.00	\$0.
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N							
Line Total:							\$0.
3	120747	647.4115	8/15/2014 No 8/15/2014		32.00 31 CQ 14/08/20	\$0.00	\$0.
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N							

Note:

8/7/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63218

Date: 21-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
✓ 22 ea	Part: 646.9710 HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140528 PO: PO25329	Rev:	Line:
32 ea	Part: 647.4114 HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140529 PO: PO25329	Rev:	Line:
32 ea	Part: 647.4115 HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140530 PO: PO25329	Rev:	Line:
4 ea	Part: 647.3813 HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140531 PO: PO25329	Rev:	Line:
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED			